



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

order 8577 - not shipped

D350-822-011
Job Sheet 183943



Part No: D350-822-011

Job Qty: 1 ea

Part Name: PA100 PUREair System for AS350/EC130



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/1/18

Job Tracking No: SIOP

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IIN-D350-822 REV.H IPP REV:A 14.02.20 NEW ISSUE DD VERF:JLM IPP REV:B 14.06.18 AS PER IIN
REV.C DD VERF:JLM IPP REV:C 15.06.03 AS PER IIN REV.D DD VERF:JLM IPP REV:C 18.07.11 AS PER
IIN REV.H DD VERF:JFS

Ship Via:

6566

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/2/18	11/2/18	0.00	0.00	Start Up Stores/Pkg-1		NOV 20 2018
110	Packaging	1 pcs	11/2/18	11/2/18	0.00	0.00	Packaging1-4		46 FEB 22 2019
120	QC	1 pcs	11/2/18	11/2/18	0.00	0.00	QC4		21 FEB 25 2019
125	Outsource	1 pcs	11/2/18	11/2/18	0.00	0.00	Outsource10		21 FEB 25 2019
130	Packaging	1 pcs	11/2/18	11/2/18	0.00	0.00	Packaging3-1		21 FEB 25 2019
135	DC	1 pcs	11/2/18	11/2/18	0.00	0.00	DC		21 FEB 25 2019
140	QC21-FG	1 Ea	11/2/18	11/2/18	0.00	0.00	QC21		21 FEB 25 2019

Part Op 125 - Issue PO to GL account 50000-25 to LEAVE W/O OPEN UNTIL SOLD PO 042754 (Send copy of PO to Pail
Descriptions: - James) Issue W/O LINE item for Pail for amount sold on sales order S/O 8577 according to sales price see
Warran for amount. (if sale price is \$23,000 - amount is \$13,400) PO can be received immediately and given to finance in
order to close work order.

130 - Identify and pack for shipping as per PPP D350-822-011

135 - Photocopy bluefile & type labels per PPP D350-822-011 CHG004

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
650.0401	Pureair Fairing Assembly	1 Ea (1 ea)	90-Start up Operation	5/28689
9752100180	Gasket	1 Ea (1 ea)	90-Start up Operation	5/16596
9945000120	Gasket (for B3e models)	1 pcs (1 ea)	90-Start up Operation	5/112872
AN821-12J	Elbow (or AN821-12K or 12S)	2 Ea (2 ea)	90-Start up Operation	5/116948
AN929-12J	Cap	1 Ea (1 ea)	90-Start up Operation	5/109922
D4925-041	Mounting Plate Assembly	1 Ea (1 ea)	90-Start up Operation	5/132046
D4931-1	Engine Fitting (for acft models B2 & previous)	1 Ea (1 ea)	90-Start up Operation	5/859439
D4931-3	Engine Fitting (For B3 Models)	1 Ea (1 ea)	90-Start up Operation	5/132789
D4931-5	Engine Fitting (for B3e models)	1 Ea (1 ea)	90-Start up Operation	5/135445
D4935-1	Mounting Bracket	6 Ea (6 ea)	90-Start up Operation	5/118378x 5/19979
D4943-1	Flex Hose	1 Ea (1 ea)	90-Start up Operation	5/042710
D4961-041	Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5/119326
D4961-043	Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5/119349
D5079-1	Placard, Eaps	2 Ea (2 ea)	90-Start up Operation	5/117918
D5090-041	Duct Assembly	1 Ea (1 ea)	90-Start up Operation	5/127836
D5105-1	Handle	2 Ea (2 ea)	90-Start up Operation	5/119860

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																							
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval																																					
Work Order Deviation				Disposition																																							
Dart Aerospace Ltd. 1270 Aberdeen Street Westborough, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S136828 Part: D350-822-011 Job No: 183943 Serial No/Batch: S136828 Revision: H Inspector: Exp Date: Instructions: TC STC SH14-14 - Issue 2, FAA/STC SR03531				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																							
								FAULT CATEGORY																																			
								<table border="1"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Temperature/Cure</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Set-up</td> <td>☐ Folio/Program</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>☐ Centre Not Concentric</td> <td>☐ BOM/Route</td> <td>☐ Grain</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave</td> <td>☐ Inspection Incomplete/Unqualified</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Cuffs</td> <td>☐ Contamination</td> <td>☐ Out of Sequence</td> <td>☐ Part Moved</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ Countersink</td> <td>☐ Off-set</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Heat Treat</td> <td>☐ Cut Too Short</td> <td>☐ Mislabeled</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Wave/Twist in Tube</td> <td>☐ Instructions Incomplete/Unclear</td> <td>☐ Fit/Function</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Misaligned/off center</td> <td>☐ Turning Sequence</td> </tr> </table>				☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish
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OTHER : _____																																											

D5110-1	Swivel Nut Fitting	1 Ea (1 ea)	90-Start up Operation	5047765
D5179-1	Doubler	2 Ea (2 ea)	90-Start up Operation	5118074
D5179-3	Doubler	2 Ea (2 ea)	90-Start up Operation	5118072
D5194-1	Doubler	2 Ea (2 ea)	90-Start up Operation	5122634
D5208-041	Blanking Plate Assembly	3 Ea (3 ea)	90-Start up Operation	5116998X1 512168302
LN9038-05012	Bolt	36 pcs (36 ea)	90-Start up Operation	5116942
LN9038-05040	Bolt	1 pcs (1 ea)	90-Start up Operation	5118062
LN9348-05	Nut	32 pcs (32 ea)	90-Start up Operation	5119875
MS20470AD3-4	Rivet, Universal Head	18 Ea (18 ea)	90-Start up Operation	51136665-40
MS21919WCH12	Clamp	1 Ea (1 ea)	90-Start up Operation	5115303
MS9592-138	Bracket	1 pcs (1 ea)	90-Start up Operation	5014155
NAS1149D0332J	Washer	70 Ea (70 ea)	90-Start up Operation	5113751
NAS43DD3-64	Spacer	1 Ea (1 ea)	90-Start up Operation	5116952
22208CM050016E	Screw	2 pcs (2 ea)	90-Start up Operation	5115091
23350CA050	Washer	2 Ea (2 ea)	90-Start up Operation	5013736
9945000160	Gasket	1 Ea (1 ea)	90-Start up Operation	5115264
D5526-1	Upper Hose Protector	1 Ea (1 ea)	90-Start up Operation	5118043
D5526-3	Lower Hose Protector	1 Ea (1 ea)	90-Start up Operation	5118052
LN9038-05016	Bolt	2 pcs (2 ea)	90-Start up Operation	51153989 5117992
BS4320-A5	Washer	56 Ea (56 ea)	110-Packaging	5153986
LN29985-A05	Anchor Nut	15 pcs (15 ea)	110-Packaging	5153988
LN9038-05018	Bolt	56 pcs (56 ea)	110-Packaging	5153989
MS20426AD3-3	Rivet	40 Ea (40 ea)	110-Packaging	5153990
QB21304	Pureair Panel Assembly	1 pcs (1 ea)	110-Packaging	5153979
QB21308	Fod Screen Assembly	1 pcs (1 ea)	110-Packaging	5153984
QB21310	Transition Duct Assembly	1 pcs (1 ea)	110-Packaging	5153985
QR10616	Vortex Tube Repair	1 pcs (1 ea)	110-Packaging	5153987
LN9038-05016	Bolt	2 pcs (2 ea)	110-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	22208CM050016E	2	12	0
	23350CA050	2	22	0
	650.0401	1	2	0
	9752100180	1	10	0
	9945000120	1	18	0
	9945000160	1	7	0
	AN821-12J	2	32	0
	AN929-12J	1	12	0
	D4925-041	1	9	0
	D4931-1	1	12	0
	D4931-3	1	8	0
	D4931-5	1	8	0
	D4935-1	6	60	0
	D4943-1	1	13	0
	D4961-041	1	8	0
	D4961-043	1	7	0
	D5079-1	2	16	0
	D5090-041	1	4	0
	D5105-1	2	18	0
	D5110-1	1	12	0
	D5179-1	2	17	0
	D5179-3	2	18	0
	D5194-1	2	13	0
	D5208-041	3	8	0
	D5526-1	1	4	0
	D5526-3	1	2	0
	LN9038-05012	36	270	0
	LN9038-05016	2	30	0
	LN9038-05040	1	2	0
	LN9348-05	32	85	0
	MS20470AD3-4	18	6,437	0
	MS21919WCH12	1	7	0
	MS9592-138	1	13	0
	NAS1149D0332J	70	2,386	0
	NAS43DD3-64	1	12	0
110-Packaging	BS4320-A5	56	174	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

LN29985-A05	15	207	0
LN9038-05016	2	30	0
LN9038-05018	56	878	0
MS20426AD3-3	40	3,533	0
QB21304	1	3	0
QB21308	1	3	0
QB21310	1	4	0
QR10616	1	7	0
Part Specifications			
Specifications could not be found.			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D350-822-011
Job Sheet 183943



Part No: D350-822-011

Job Qty: 1 ea

Part Name: PA100 PUREair System for AS350/EC130



Part Weight: 0 lbs

Status: Hold

Priority: Medium

Job Created: 10/1/18

Job Tracking No: SIOP

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IIN-D350-822 REV.H , DSI9815 REV.A IPP REV:A 14.02.20 NEW ISSUE DD VERF:JLM IPP REV:B 14.06.18
AS PER IIN REV.C DD VERF:JLM IPP REV:C 15.06.03 AS PER IIN REV.D DD VERF:JLM IPP REV:C
18.07.11 AS PER IIN REV.H DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/20/18	11/2/18	0.00	0.00	Start Up Stores/Pkg-1		
110	Packaging	1 pcs		11/2/18	0.00	0.00	Packaging1-4		
113	Small Fab - 2 - B4B	1 pcs		11/2/18	0.00	0.00	Small Fab - 1 - B4B		AP
116	QC 5	1 pcs		11/2/18	0.00	0.00	QC 5 - 10		JA
120	QC	1 pcs		11/2/18	0.00	0.00	QC4		
125	Outsource	1 pcs		11/2/18	0.00	0.00	Outsource10		
130	Packaging	1 pcs		11/2/18	0.00	0.00	Packaging3-1		
135	DC	1 pcs		11/2/18	0.00	0.00	DC		
140	QC21-FG	1 Ea		11/2/18	0.00	0.00	QC21		

Part Op 113 - REPLACE RECEPTACLE KIT AS PER DSI9815

Descriptions: 125 - Issue PO to GL account 50000-25 to LEAVE W/O OPEN UNTIL SOLD PO _____ (Send copy of PO to Pall - James) Issue W/O LINE item for Pall for amount sold on sales order S/O _____ according to sales price see Warran for amount. (if sale price is \$23,000 - amount is \$13,400) PO can be received immediately and given to finance in order to close work order.

130 - Identify and pack for shipping as per PPP D350-822-011

135 - Photocopy bluefile & type labels per PPP D350-822-011 CHG005

PALL QB05003 Serial RE10-10441

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
650.0401	Pureair Fairing Assembly	1 Ea (1 ea)	90-Start up Operation	
9752100180	Gasket	1 Ea (1 ea)	90-Start up Operation	
9945000120	Gasket (for B3e models)	1 pcs (1 ea)	90-Start up Operation	
AN821-12J	Elbow (or AN821-12K or 12S)	2 Ea (2 ea)	90-Start up Operation	
AN929-12J	Cap	1 Ea (1 ea)	90-Start up Operation	
D4925-041	Mounting Plate Assembly	1 pcs (1 ea)	90-Start up Operation	
D4931-1	Engine Fitting (for acft models B2 & previous)	1 pcs (1 ea)	90-Start up Operation	
D4931-3	Engine Fitting (For B3 Models)	1 pcs (1 ea)	90-Start up Operation	
D4931-5	Engine Fitting (for B3e models)	1 pcs (1 ea)	90-Start up Operation	
D4935-1	Mounting Bracket	6 pcs (6 ea)	90-Start up Operation	
D4943-1	Flex Hose	1 pcs (1 ea)	90-Start up Operation	
D4961-041	Tube Assembly	1 pcs (1 ea)	90-Start up Operation	
D4961-043	Tube Assembly	1 pcs (1 ea)	90-Start up Operation	
D5079-1	Placard, Eaps	2 pcs (2 ea)	90-Start up Operation	
D5090-041	Duct Assembly	1 pcs (1 ea)	90-Start up Operation	
D5105-1	Handle	2 pcs (2 ea)	90-Start up Operation	
D5110-1	Swivel Nut Fitting	1 pcs (1 ea)	90-Start up Operation	
D5179-1	Doubler	2 pcs (2 ea)	90-Start up Operation	
D5179-3	Doubler	2 pcs (2 ea)	90-Start up Operation	
D5194-1	Doubler	2 pcs (2 ea)	90-Start up Operation	
D5208-041	Blanking Plate Assembly	3 pcs (3 ea)	90-Start up Operation	
LN9038-05012	Bolt	36 pcs (36 ea)	90-Start up Operation	
LN9038-05040	Bolt	1 pcs (1 ea)	90-Start up Operation	
LN9348-05	Nut	32 pcs (32 ea)	90-Start up Operation	
MS20470AD3-4	Rivet, Universal Head	18 Ea (18 ea)	90-Start up Operation	
MS21919WCH12	Clamp	1 Ea (1 ea)	90-Start up Operation	
MS9592-138	Bracket	1 pcs (1 ea)	90-Start up Operation	
NAS1149D0332J	Washer	70 Ea (70 ea)	90-Start up Operation	
NAS43DD3-64	Spacer	1 Ea (1 ea)	90-Start up Operation	
22208CM050016E	Screw	2 pcs (2 ea)	90-Start up Operation	
23350CA050	Washer	2 Ea (2 ea)	90-Start up Operation	
9945000160	Gasket	1 Ea (1 ea)	90-Start up Operation	
D5526-1	Upper Hose Protector	1 pcs (1 ea)	90-Start up Operation	
D5526-3	Lower Hose Protector	1 pcs (1 ea)	90-Start up Operation	
LN9038-05016	Bolt	2 pcs (2 ea)	90-Start up Operation	
BS4320-A5	Washer	56 Ea (56 ea)	110-Packaging	
LN29985-A05	Anchor Nut	15 pcs (15 ea)	110-Packaging	
LN9038-05018	Bolt	56 pcs (56 ea)	110-Packaging	
MS20426AD3-3	Rivet	40 Ea (40 ea)	110-Packaging	
QB21304	Pureair Panel Assembly	1 pcs (1 ea)	110-Packaging	
QB21308	Fod Screen Assembly	1 pcs (1 ea)	110-Packaging	
QB21310	Transition Duct Assembly	1 pcs (1 ea)	110-Packaging	
QR10616	Vortex Tube Repair	1 pcs (1 ea)	110-Packaging	
LN9038-05016	Bolt	2 pcs (2 ea)	110-Packaging	
DSI 9815-011	Replacement Receptacle	1 pcs (1 ea)	113-Small Fab - 2 - B4B	5140514

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	22208CM050016E	2	22	0
	23350CA050	2	45	0
	650.0401	1	9	0
	9752100180	1	0	0
	9945000120	1	9	0
	9945000160	1	13	0
	AN821-12J	2	30	0
	AN929-12J	1	17	0
	D4925-041	1	3	0
	D4931-1	1	9	0
	D4931-3	1	5	0
	D4931-5	1	6	0
	D4935-1	6	69	0
	D4943-1	1	15	0
	D4961-041	1	8	0
	D4961-043	1	9	0
	D5079-1	2	30	0
	D5090-041	1	9	0
	D5105-1	2	24	0
	D5110-1	1	28	0
	D5179-1	2	19	0
	D5179-3	2	20	0
	D5194-1	2	5	0
	D5208-041	3	12	0
	D5526-1	1	10	0
	D5526-3	1	8	0
	LN9038-05012	36	337	0
	LN9038-05016	2	103	0
	LN9038-05040	1	46	0
	LN9348-05	32	410	0
	MS20470AD3-4	18	5,777	0
	MS21919WCH12	1	45	0
	MS9592-138	1	19	0
	NAS1149D0332J	70	2,702	0
	NAS43DD3-64	1	28	0
110-Packaging	BS4320-A5	56	6	0
	LN29985-A05	15	389	0
	LN9038-05016	2	103	0
	LN9038-05018	56	731	0
	MS20426AD3-3	40	2,027	0
	QB21304	1	0	0
	QB21308	1	0	0
	QB21310	1	0	0
	QR10616	1	0	0
	DSI 9815-011	1	10	0
113-Small Fab - 2 - B4B				

Part Specifications

Specifications could not be found.

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-822 REV. H AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-822 REV. 6 OR LATER APPROVED REVISION

REF. TCCA STC: SH14-14
REF. FAA STC: SR03538NY
REF. ANAC STC: 2014S07-11
REF. JCAB STC: STC-372-OSA/STC-371-OSA
REF. EASA STC: 10056574

1.0 PURPOSE

The purpose of this Service Instruction is to facilitate the replacement of the QD3072-46 Receptacles that are installed on the QB21308 Assembly Screen manufactured by Pall Aerospace as part of the D350-822-011/-013 PA100 PUREair System with the DSI 9815-011 Replacement Receptacle kit. The intent of this DSI has been incorporated into D350-822-011 at CHG 005 and D350-822-013 at CHG 003.

2.0 PROCEDURE

2.1 To install the DSI 9815-011 Replacement Receptacle Kits,

- 2.1.1 Open or remove the Upper Engine Cowl per the Aircraft Maintenance Manual.
 - 2.1.2 Remove the Air Intake Seal and the entire QB21308 Assembly Screen by removing qty(22) fasteners per the Aircraft Maintenance Manual. Retain Hardware.
 - 2.1.3 Separate the FOD screen from the QB21496 Receptacle by turning the 1/4 turn fasteners and lift the FOD screen per Figure 1.
 - 2.1.4 Drill out the retaining rivets and remove qty(4) QD3072-46 Receptacles from the QB21496 Receptacle. Remove any adhesive residue.
 - 2.1.5 Position the qty(4) D5713-041 Receptacle Assy in the location shown in Figure 2. Transfer drill 2x $\varnothing 0.098$ " holes with CSK $\varnothing 0.179$ " $\angle 100^\circ$ on the top side from the D5713-041 Receptacle Assy to the QB21496 Receptacle. Touch up holes with Alodine 1200 per MIL-C-5541.
 - 2.1.6 Mask nutplate holes and touch up the affected areas with prime and paint per ICA-D350-822.
 - 2.1.7 Install qty(4) D5713-041 Receptacle Assy with qty(2) MS20426AD3-(5) Rivets per Figure 2.
- NOTE: Although not generally necessary, it is acceptable to use longer or shorter MS20426AD3-X Rivets
- 2.1.8 Remove qty(4) 1/4 Turn Fasteners from the FOD Screen per Figure 1.
 - 2.1.9 Reinstall the FOD screen on the QB21496 Receptacle using qty(4) AN4-5A bolts and qty(4) NAS1149D0432J Washers per Figure 2. Torque bolts to 50-70 in-lb (5.6-7.9 N-m).
 - 2.1.10 Ensure the Engine Intake is clear.
 - 2.1.11 Reinstall the QB21308 Assembly Screen between the Engine Intake Duct and the Air Intake Seal using qty(22) fasteners retained at step 2.1.2 per the Aircraft Maintenance Manual.
 - 2.1.12 Reinstall the Upper Engine Cowl per the Aircraft Maintenance Manual.
 - 2.1.13 Update the Aircraft Log Book to indicate installation of the DSI 9815-011 Replacement Receptacle Kit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 18.12.10
CERT. NO.: SH14-14
ISSUE NO.: 2

APPROVED

A	NEW ISSUE	VS	18.12.10
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	WK	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9815	SHEET 1 OF 4
APPROVED	VS	TITLE	SCALE
DE APPR.	DS	REPLACEMENT RECEPTACLE	NTS
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2.2 To remove the FOD screen,

2.2.1 Open Upper Engine Cowl.

2.2.2 Remove qty(4) AN4-5A bolts and qty(4) NAS1149D0432J Washers per Figure 3 and remove the FOD screen.

2.3 Reinstallation of FOD screen,

2.3.1 Ensure the Engine Intake and FOD Screen are clear.

2.3.2 Install the FOD Screen with qty(4) AN4-5A bolts and qty(4) NAS1149D0432J Washers per Figure 2.

2.3.3 Close Upper Engine Cowl.

3.0 WEIGHT AND BALANCE

The installation of the DSI 9815-011 Replacement Receptacle Kit has negligible effect on Weight and Balance

4.0 PARTS LIST

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9815-011	REPLACEMENT RECEPTACLE KIT
4	D5713-041	RECEPTACLE ASSY
4	AN4-5A	BOLT
8	MS20426AD3-5	RIVET
4	NAS1149D0432J	WASHER

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MFG. APPR.	N/A	DSI 9815 SHEET 2 OF 4
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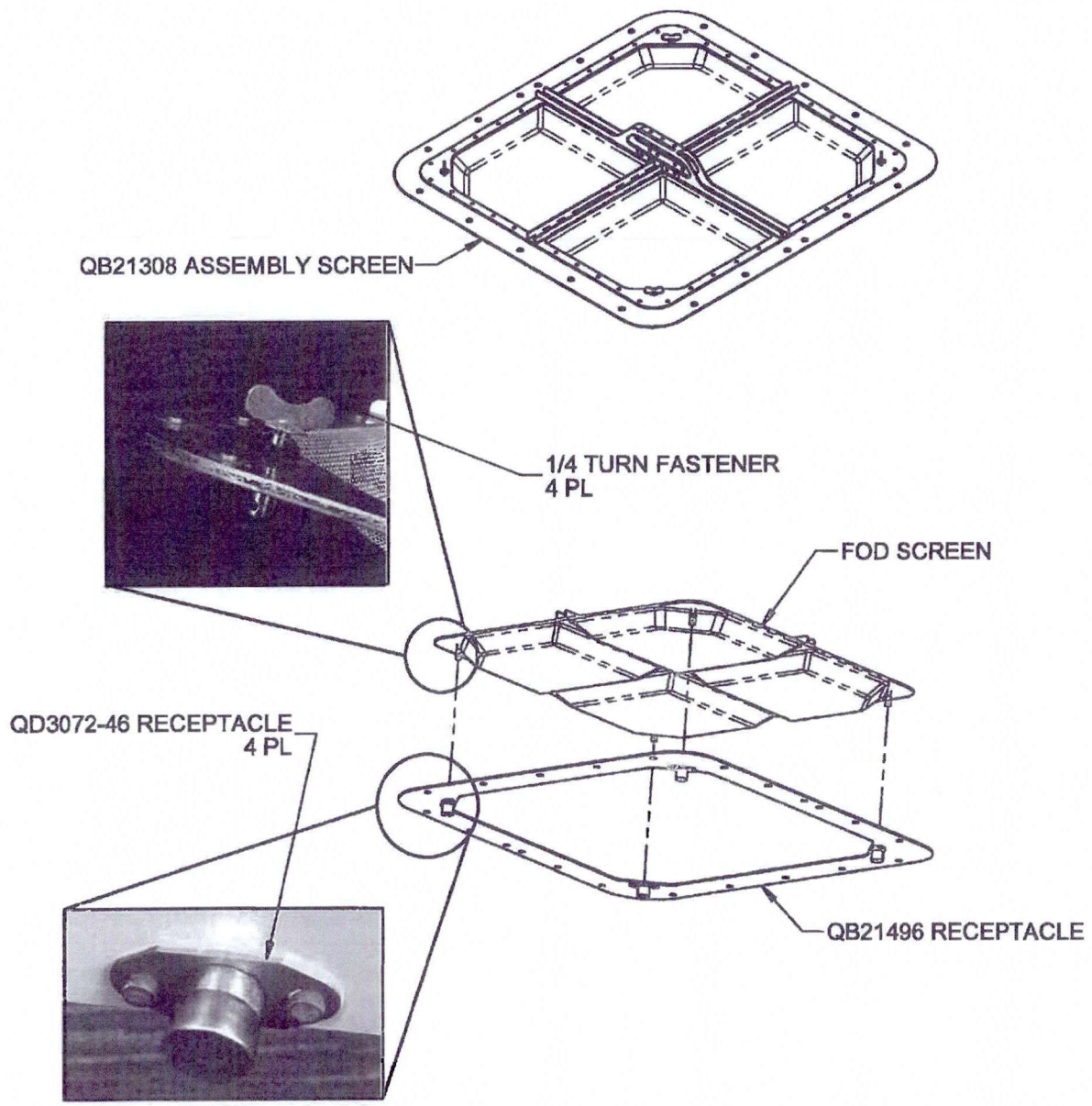


Figure 1 - QB21308 Assembly Screen

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DESIGN	VS
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DSI 9815

REV. A
SHEET 3 OF 4

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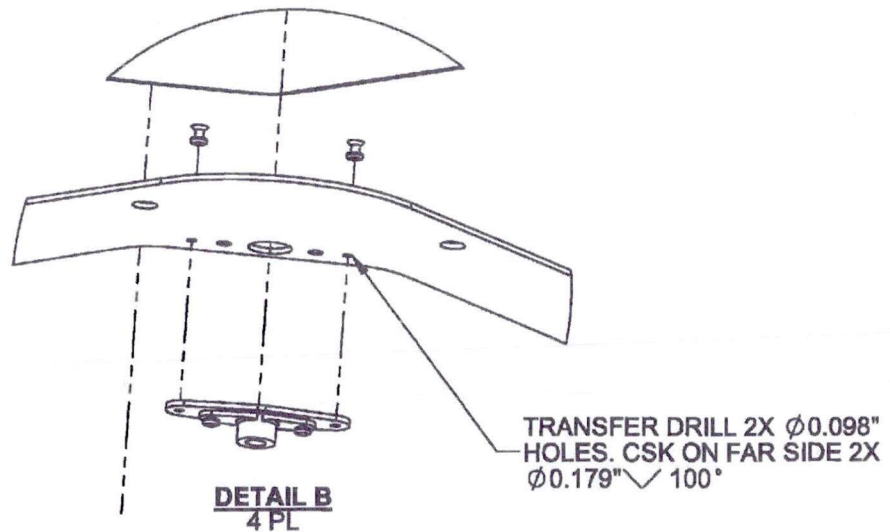
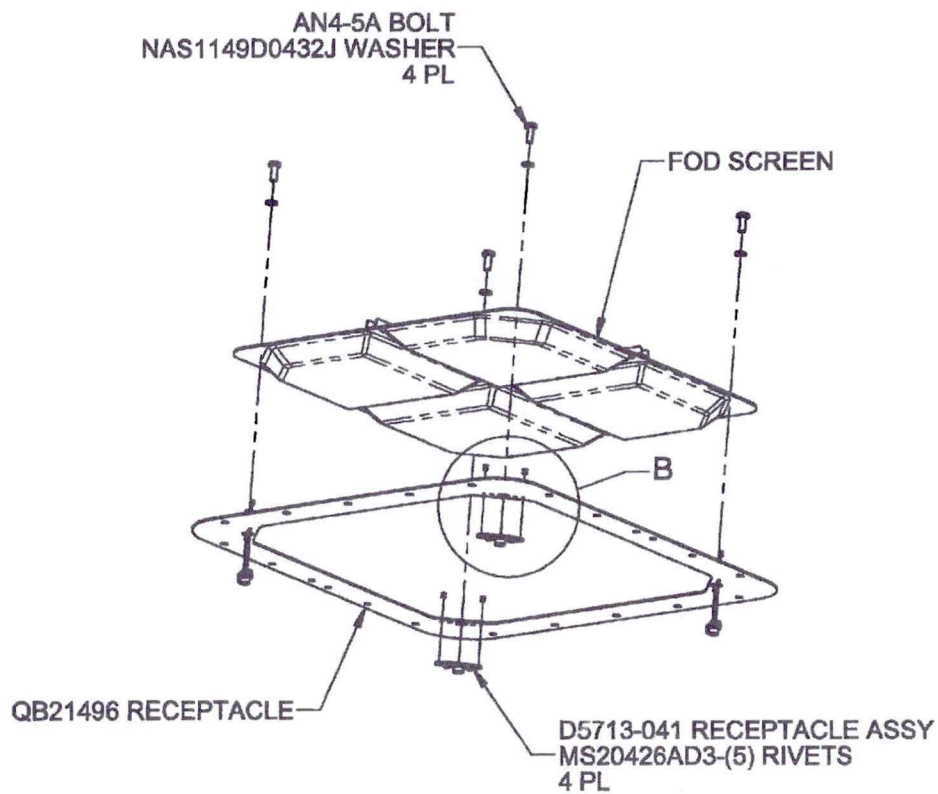


Figure 2 - DSI 9815-011 Replacement Receptacle Kit

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MFG. APPR.	N/A	DSI 9815	SHEET 4 OF 4
APPROVED	VS	TITLE	SCALE
DE APPR.	DS	REPLACEMENT RECEPTACLE	NTS
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1. Approving Competent Authority/Country Civil Aviation Authority/ United Kingdom		2. AUTHORISED RELEASE CERTIFICATE EASA FORM 1		3. Form Tracking Number: 0150334	
4. Organisation Name and Address: PALL Pall Corporation PALL EUROPE LTD. Pall Aerospace Division Cardrew Industrial Estate, Redruth, Cornwall, TR15 1SS, UK Tel No. 00 44 (0)1209 884200 Fax No. 00 44(0)1209 884310				5. Work Order/Contract/ Invoice: 4503324242	
6. Item	7. Description	8. Part No.	9. Qty	10. Serial No.	11. Status/Work
1	Assy Separator Engine Air Particle Iss 3	QB05008	5	RE10-10441 to 10445 inc	New
12. Remarks Dart Aerospace Ltd 1270 Aberdeen Street Hawkesbury K6A 1K7 Ontario CANADA Pall Aerospace Batch No. RD18018676 (PALL REF - SAP ITEM No: 10) DDP 642 Iss C REFERS. Note - QB05008 is a Kit of following parts: QB21304, QB21310 & QB21308. <i>+ Hardware</i> Guidance and information on disposal / recycling of this product at the end of its life can be obtained from the "Disposal Instruction Guidance" section on Pall web site: https://aerospace.pall.com/en/disposal-instructions.html Order No. "STO" Order. This document has been issued according to an approved computer-generated signature procedure.					

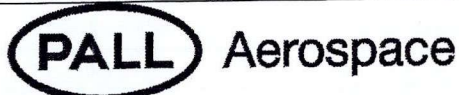
13a. Certifies that the items identified above were manufactured in conformity to: ☒ approved design data and are in a condition for safe operation ☐ non-approved design data specified in block 12		14a. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12 was accomplished in accordance with Part 145 and in respect to that work the items are considered ready for release to service.	
13b. Authorised Signature  Electronic Signature on File	13c. Approval/Authorisation Number UK.21G.2630	14b. Authorised Signature	14c. Certificate/Approval Ref. No UK.145.00296
13d. Name Dave Saunders - Line Leader EAPs - 0414	13e. Date (dd mmm yyyy) 04 Feb 2019	14d. Name	14e. Date (dd mmm yyyy)

USER/INSTALLER RESPONSIBILITIES

This certificate does not automatically constitute authority to install.

Where the user/installer performs work in accordance with regulations of an airworthiness authority different than the airworthiness authority specified in block 1, it is essential that the user/installer ensures that his/her airworthiness authority accepts items from the airworthiness authority specified in block 1.

Statements in blocks 13a and 14a do not constitute installation certification. In all cases aircraft maintenance records must contain an installation certification issued in accordance with the national regulations by the user/installer before the aircraft may be flown.



PRODUCTION ACCEPTANCE TEST CERTIFICATE

This is an Electronically controlled document which is maintained with Full Password Access for all users. The "Insp Stamp" column relates to an individual whose password is electronically controlled, a "wet stamp" is therefore no longer required.

Test Unit Desc	Centrisep EAPS	Report No:	FC/009	
Drawing No	QB05008	Serial No.	RE10-10441	
Part No	QB05008	Batch No.	R518018676	
ECR / Concession No		Issue	4A	
Cust Spec	RSB05008	Test Sched	ATPB05008	
Test Fluid	Air	Test Set-up		
Rig Or Test No		Issue		
Comment	MQC 414A	Assembler	P. FRAZER	
Insp/Approved By		Clock No.	402585	
Tester	A. SAUNDERS			
Date	312/19			

	PROCEDURE	REQUIREMENT	RESULT	Pass/Fail
3.1	Check that the label requirements and part marking are in accordance with Sheet 2	Confirm	Confirmed	Pass
3.2	Ensure the QB05008 assembly conforms to the QB05008 Sheet 2 dimensions.	Confirm	Confirmed	Pass
3.3	Check the weight of the unit does not exceed 10kg.	Confirm	8.7kg	Pass
3.4	Check that proof pressure and crack detect tests have been performed on manifold.	Confirm	Confirmed	Pass
3.5	Check FOD screen mesh is intact with no broken mesh strands or irregular deformation.	Confirm	Confirmed	Pass
3.6	Check FOD screen receptacles are secure with no movement under finger pressure.	Confirm	Confirmed	Pass
3.7	Check FOD screen fits securely to receptacle plate and all 4 off studs engage positively with their corresponding receptacles.	Confirm	Confirmed	Pass
3.8	Check retaining washer has been added to 4 off quarter turn studs.	Confirm	Confirmed	Pass
3.9	Check manifold port thread engagement. Ensure protective cap is fitted.	Confirm	Confirmed	Pass
3.10	Check electrical bonding resistance is equal to or less than 100 milliohms.	Confirm	Confirmed	Pass
4.1	Check overall unit cleanliness.	Confirm	Confirmed	Pass
4.1a	Check there are no material imperfections or foreign matter embedded.	Confirm	Confirmed	Pass
4.1b	Check surface for unclean, rough, misaligned or containing cracks, nicks or other flaws.	Confirm	Confirmed	Pass

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4.1 c	Check for any components that are missing, malformed, fractured or otherwise damaged.	Valid on 03 Feb 2019 only. Confirmed	Confirmed	Pass
4.1 d	Check for any components that are loose or otherwise not securely retained.		Confirmed	Pass
4.1 e	Check for incorrect assembling or improper positioning of components.		Confirmed	Pass
4.1 f	Check for faulty workmanship or other irregularities e.g. Marking. Check for missing, insufficient, incorrect, illegible or non permanent text.		Confirmed	Pass
4.1 g	Check to ensure all components are installed and secured in accordance with drawing instructions.		Confirmed	Pass
4.1 h	Check that unit is free from all foreign objects: e.g. Swarf and rivet tails. Ensure unit is properly painted and is in a clean condition. Visually check unit for workmanship, no damage is permissible.		Confirmed	Pass
	PASS/FAIL			
RESULTS OF TEST :- <i>Pass</i>				
MQC 414A				



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

ORDER ACKNOWLEDGEMENT

CUSTOMER

Customer Code: CHTAH01

Sold To: HTA Helicopters Lda

Casa de Lagoa
8135-107 Almancil
Portugal
Phone: 011 351 289 435112

Ship To: HTA Helicopters Lda
Heliporto Miguel Barros, EN 270, Quinta Morgado de
Apra
8100-277 Loulé
Portugal

ORDER

Order No : 8577

Date: 8/2/18

Ship-To Contact: Joao Batalha

Email:

Cust PO No: 95

FOB: Shipping Point

Ship Via:

Freight Terms: Third Party Billing

Terms: Prepay

INCO Terms: Ex Works

Order Taker: Kinga Lysiak

Order Taker Phone:

Order Taker Email: klysiak@dartaero.com

Line No	Due Date	Ship Date	Part	Description/Note	Quantity	Unit	Price	Unit	Extended Price
2	2/26/19	2/28/19	D350-822-011	PA100 PUREair System for AS350/EC130	2	pcs	\$25,000.00USD	pcs	\$50,000.00 USD
				Services - Freight Charges					\$359.00
				Special Discount (Sales)			-10.00		\$-5,000.00

Sub Total \$45,359.00 USD

Grand Total \$45,359.00 USD

ORDER NOTES

please ship with 11277

Ship via Fedex, dart's account, duties and taxes billed to receiver

Custom Clearance To Be Billed To Receiver

Duties & Taxes To Be Billed To Receiver

Ship Order As Soon As Possible

Ship Order Complete

Waiting On Freight

All Prices Quoted In USD & Valid For 30 Days. All Parts Subject To Prior Sale & Are Ex-Works Manufacturing Facility In Hawkesbury, ON, Canada

Job 183943
5136828 - 183943
5136831 - 183942